

Work Order ID 144524

Tuesday, April 19, 2016 3:24:33 PM

144524

Page 1

Item ID: DSI 9731-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: GHL Upgrade
 Start Date: 4/20/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 4/21/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference: #16-4-19

Approvals: Process Plan: Em Date: 16/04/19 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9731	A

MCS 1604-20

100 Document Control 0.00
100
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP DSI9731-011 CHG001

2X DAS
27
9-89
 APR 20 2016

110 Pick Kit 0.00
110
 Packaging Memo 0.00
 Packaging

2 DAS
6
9-89
 APR 20 2016

120 QC4- 100% Inspect kits for completeness 0.00
120
 QC Memo 0.06
 Quality Control

2X DAS
27
9-89
 APR 20 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
						Completed By															
						Lead hand / Supervisor Approval Verification															
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : ☐																					

Tuesday, April 19, 2016 3:24:33 PM

144524

Page 2

Item ID: DSI 9731-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: GHL Upgrade

Stop *NS2*

Start Date: 4/20/2016 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 4/21/2016 **Req'd Qty:** 2.00

~

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

0.00

Packaging

Memo

Identify and pack for shipping as per PPP DSI9731-011

Location:

DAS

27

9-89

APR 20 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.20

Quality Control

APR 20 2016

20160420

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Tuesday, April 19, 2016 3:24:40 PM

144524

DSI 9731-011

Start Date: 4/20/2016**Required Date:** 4/21/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 16.02.05 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5300-1 GHL Bushing		Manufactured	No				Each	34.0000	2	4		DAS 6 9-89	DAS 28 9-89
D5300-1 DAS 27 9-89 <u>Location</u> FP001 141838 <u>Loc Qty</u> 34 34 <u>Loc Code</u>													
D5301-1 GHL Plug		Manufactured	No				Each	34.0000	2	4		DAS 6 9-89	DAS 28 9-89
D5301-1 DAS 27 9-89 <u>Location</u> ST162 141839 <u>Loc Qty</u> 34 34 <u>Loc Code</u>													
AN6C52A BOLT		Purchased	No				Each	51.0000	2	4		DAS 6 9-89	DAS 28 9-89
AN6C52A DAS 27 9-89 <u>Location</u> over009 m134535 ST333 m134291 <u>Loc Qty</u> 50 50 1 1 <u>Loc Code</u>													

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Page 2

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Work Order ID: 144524

144524

Parent Item: DSI 9731-011

DSI 9731-011

Parent Item Name: GHL Upgrade

Start Date: 4/20/2016

Required Date: 4/21/2016

Start Qty: 2.00

Required Qty: 2.00

MS21043-6

Purchased

No

Each

79.0000

2 4

MS21043-6

NUT

Location

Loc Qty

Loc Code

FG	20	
103693	20	
FP001	29	
m134365	29	
ST302	30	
m134557	30	

DAS
27
9-89

DAS
28
9-89

APR 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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OTHER : ☐					

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D117-762 REV. D AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D117-762 REV. 3

REF FAA STC: SR01853SE

REF: TC LETTER OF ACCEPTANCE RDIMS-4374899

REF EASA STC: EASA.10017063

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to replace the ground handling lugs (D3864-1 Bushings, AN6C51A Bolts and MS21043-6 Nuts) on the D145-762-XXX Skid tubes with a structurally superior lug design. This service instruction only affects D145-762-043/-013/-113 Skid tubes at change 004 or earlier and D145-762-045/-015/-115 Skid tubes at change 001. It is highly recommended to install DSI 9731-011 GHL Upgrade Kit in order to prevent early structural failure of the D145-762-XXX Skid tubes. Each DSI 9731-011 GHL Upgrade Kit provides the necessary parts and hardware for installation on one skid tube.

2.0 INSTALLATION

- 2.1 Remove (qty 4) D3864-1 Bushings per Skid tube by removing (qty 2) AN6C51A Bolts and (qty 2) MS21043-6 Nuts
- 2.2 Loosely install (qty 2) D5300-1 GHL Bushing & (qty 2) D5301-1 GHL Plug wet with Proseal 890 or MIL-S-8802 Class B2 Sealant in location shown in Figure 1.
- 2.3 Install AN6C52A Bolts and (qty 2) MS21043-6 Nuts in accordance with Figure 1. Clean up squeezed out Proseal and apply fillet seal around D5300-1 & D5301-1.
- 2.4 Torque AN6C52A Bolts 180 - 190 in-lbs (18.1 - 21.5 N-m).

3.0 PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9731-011	GHL UPGRADE KIT
2	D5300-1	GHL BUSHING
2	D5301-1	GHL PLUG
2	AN6C52A	BOLT
2	MS21043-6	NUT

4.0 WEIGHT AND BALANCE

There is negligible weight and balance change associated with this modification.

A	NEW ISSUE	AP	15.11.02
REV.	DESCRIPTION		BY DATE
DESIGN	AP	DART AEROSPACE, LTD EUGENE, OR	
DRAWN	AP		
CHECKED	DB.	DRAWING NO.	REV.A
MFG. APPR.	N/A	DSI 9731	SHEET 1 OF 2
APPROVED	CH	TITLE	SCALE
DE APPR.		GHL UPGRADE KIT	NTS
DATE	15.11.02	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE, LTD.	

u/o 14524

8m 16/04/19

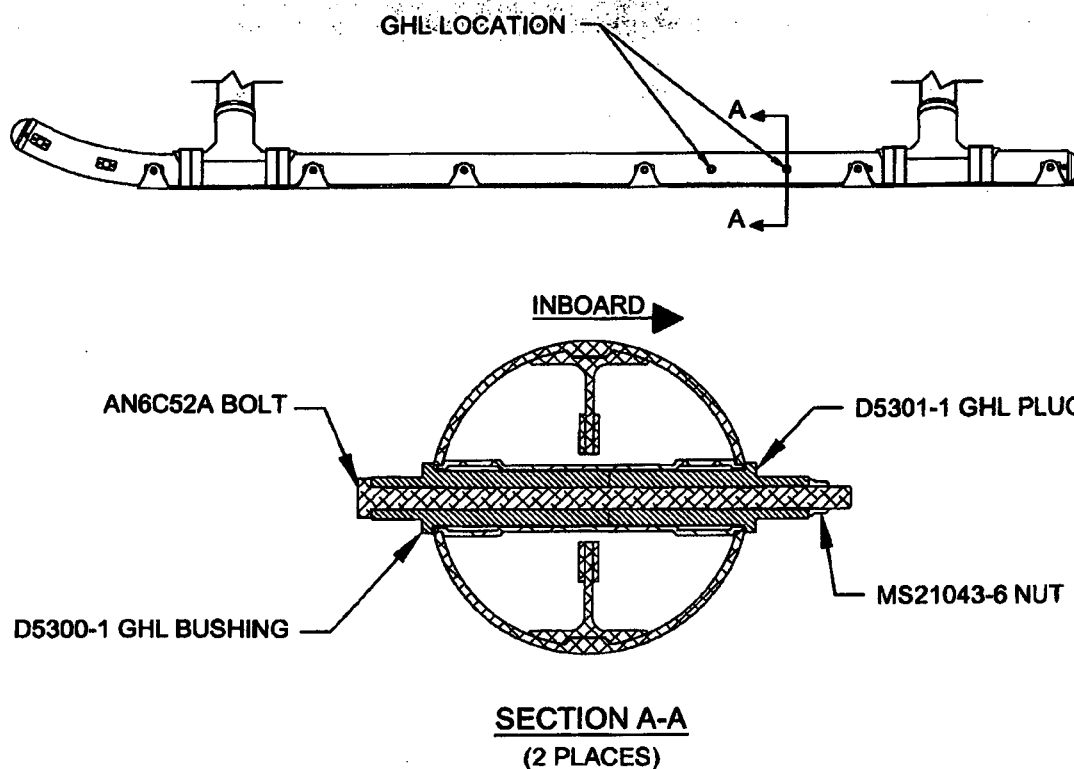


FIGURE 1 - GHL UPGRADE INSTALLATION

DESIGN	AP	DART AEROSPACE, LTD EUGENE, OR	
DRAWN	AP		
CHECKED	ASS	DRAWING NO.	REV.A
MFG. APPR.	N/A	DSI 9731	SHEET 2 OF 2
APPROVED	CA	TITLE	SCALE
DE APPR.	TH	GHL UPGRADE KIT	NTS
DATE	15.09.15	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE, LTD.	